

Work Order ID 126742

February-09-15 9:14:10 AM

126742

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Item ID: D119-796-151

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Crosstube, STD w/ Peg Steps (MKII)

Stop

NS2

Start Date: 11/24/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/24/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-151	0 0 A.P. 15-02-09								
120	Pick Kit	0.00							DAS
120	Packaging					1			41
Packaging	Memo	0.00							9-89
Packaging									15-2-9
130	Crosstubes	0.00							DAS
130						1			41
Crosstubes	Memo	0.00							9-89
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-151								15-2-9
	Torque all clamps to 50-70 IN-LBS.								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						0			DAS
QC	Memo	0.00							9
Quality Control	***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***								9-89

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Item ID: D119-796-151 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Crosstube, STD w/ Peg Steps (MKII)
 Start Date: 11/24/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/24/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-151								
160		0.00							
160	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

O.K. for release
 A.P.
 15.02.12

W 15-02-12

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D119-796-151

Required Date: 11/24/14

Required Qty: 1.00

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C6A		Purchased	No				Each	530.0000		8			
AN4C6A Bolt N/A A.P. 15.02.09													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				FG			14						
					103344		4						
					121657		10						
				ST312A			200						
					m131320		200						
				ST345			316						
					m130716		116						
					m131410		200						
D119-796-141		Manufactured	No				Each	0.0000		①		DAS 41 9-89	15-2-9
D119-796-141 Fwd Crosstube, STD w/o Peg Steps (MKII)													
D2274		Manufactured	No				Each	38.0000		8			
D2274 Radius Block N/A A.P. 15.02.09													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				FG			12						
					86855		12						
				ST012a			26						
					121589		24						
					124363		2						
D5149-043		Manufactured	No				Each	0.0000		2		DAS 41 11-89	15-2-9
D5149-043 Fwd Sten Base Assembly N/A A.P. 15.02.09													

Picklist Print

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Parent Item: D119-796-151

D119-796-151

Parent Item Name: Fwd Crosstube, STD w/ Peg Steps (MKII)

Start Date: 11/24/14

Required Date: 11/24/14

Start Qty: 1.00

Required Qty: 1.00

D5150-043

Manufactured No

Each

0.0000

2

D5150-043

Clamp Assembly

**

N/A

A.P.

15.02.09

A.P.
15.02.09

D5123-3

QTY 4

CUSHION

BN: 127133
126747

#

2

2

DAS
41
9-89

15-2-9

A.P.
15.02.09

D5144-041

QTY 2

FWD STEP ASSY

BN: 128568

2

DAS
41
9-89

15-2-9

MS21920-22

QTY 4

CLAMP

BN: 128636

4

DAS
41
9-89

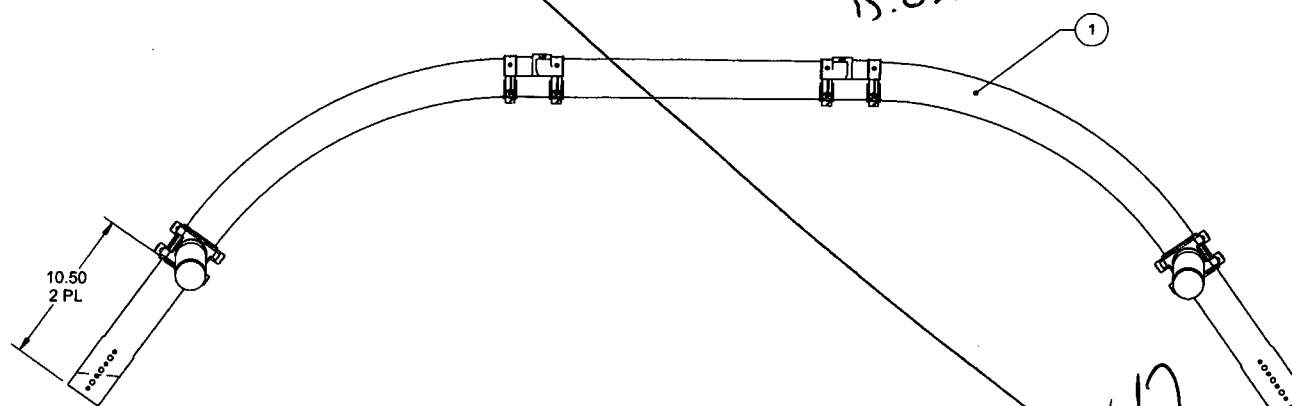
15-2-9

A.P.

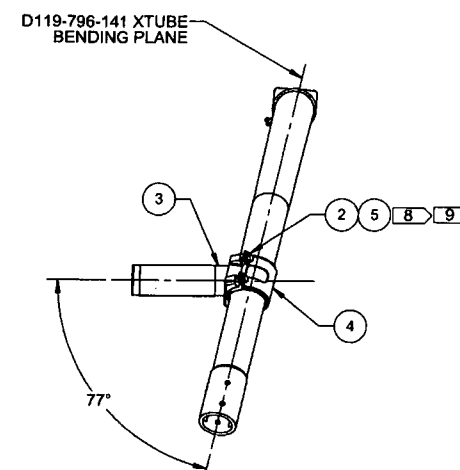
15.02.09

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	8	D2274	RADIUS BLOCK
3	2	D5149-043	STEP BASE ASSY
4	2	D5150-043	CLAMP ASSEMBLY
5	8	AN4C6A	BOLT

SEE ATTACHED
A.P.
15.02.09



D119-796-151 XTUBE ASSY (AW119 MKII FWD)



D119-796-151 XTUBE ASSY (AW119 MKII FWD)
(AUXILIARY VIEW)

UNDER REVIEW

14.12.09 AP

RELEASED
2014-11-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 22.39 lbs
- 8) TORQUE AN4C6A BOLTS 50-70 IN-LBS. QTY 4 PER SIDE
- 9) POSITION AND INSTALL D5149-043 STEP BASE ASSY AND D5150-043 CLAMP ASSEMBLY USING DT10089

APPROVED

B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP		
DRAWN	AP		
CHECKED	CP		
MFG. APPR.	JLM		
APPROVED	MP		
DE APPR.	DS		
DATE	14.11.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

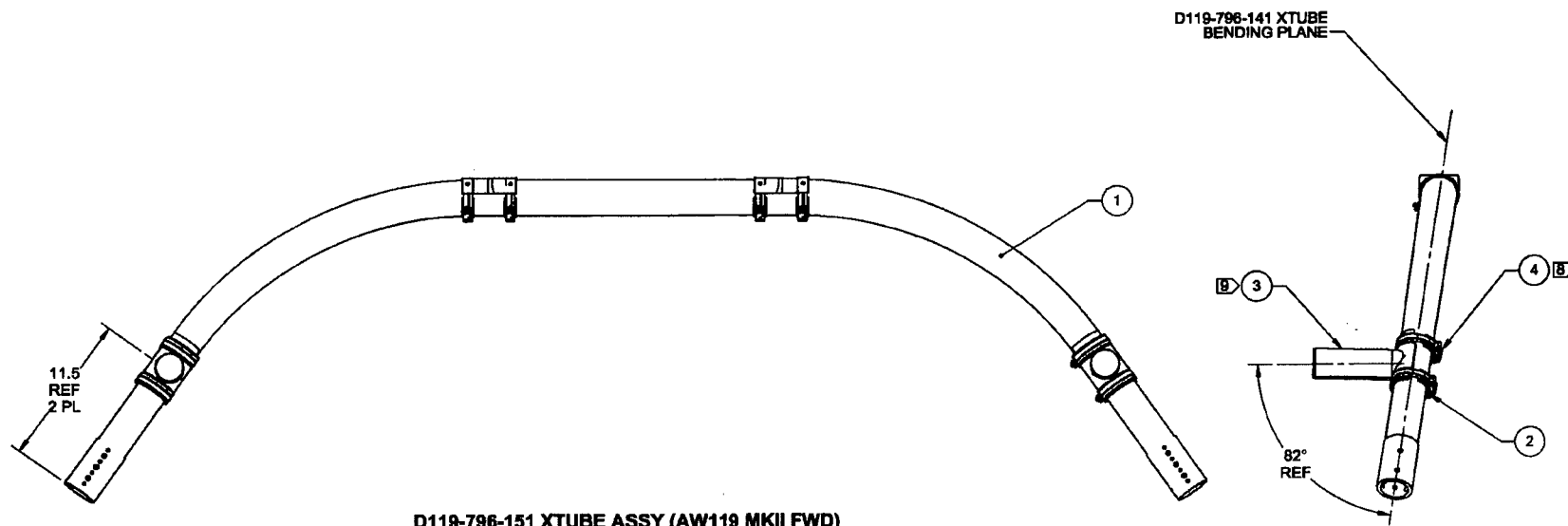
DRAWING NO.
D119-796-151

REV. B
SHEET 1 OF 1

TITLE
XTUBE ASSY (AW119 MKII FWD) SCALE
NTS

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ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

RELEASED

2015 FEB 09

ECN 15-516

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	JLM	D119-796-151	SHEET 1 OF 1
APPROVED	MS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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